

Work Order ID 53250

October 28, 2009 2:34:15 PM



Page 1

Item ID: PB67-43001-37

Accept



Setup Start



Revision ID: C

Stop



Item Name: Tube Arm Assembly

Start Date: 10/29/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/16/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *09-10-28* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	c								

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble by drilling thru both -125 and -343 as per dwg
2- install spring slotted pin as per dwg*Pp 09/11/30**(1)*

110

0.00



QC5-Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*⇒ S 02/11/30**(XU)*

120

0.00



Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: *1:00*
OVEN TEMPERATURE: *320°*
FINISH TIME: *1:30**BR 09-12-01**(D)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 10/29/2009 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

M 09/12/01

(X1)

Φ

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

09/12/02 ①

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/12/03

MF
09-12-02

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 53250

Parent Item: PB67-43001-37RevC

Parent Item Name: Tube Arm Assembly


Comments:

Start Date: 10/29/2009

Required Date: 11/16/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
240-107  SPRING SLOTTED PIN		Purchased	No			100	Each	74.0000	1.0000			

Pl 09/11/30


Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
112813

74
74

PB67-43001-125RevB1 Manufactured No

Clevis

100 Each 3.0000 1.0000


① ✓

Pl 09/11/30

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
23993

3
3

PB67-43001-343RevB1 Manufactured No

Tube Arm

100 Each 11.0000 1.0000


① ✓

Pl 09/11/30

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
41213
41507

11
6
5

① ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

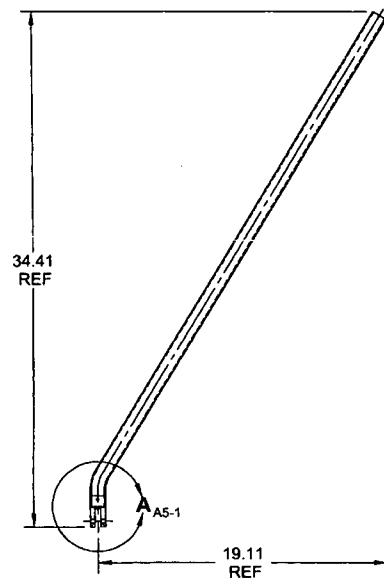
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

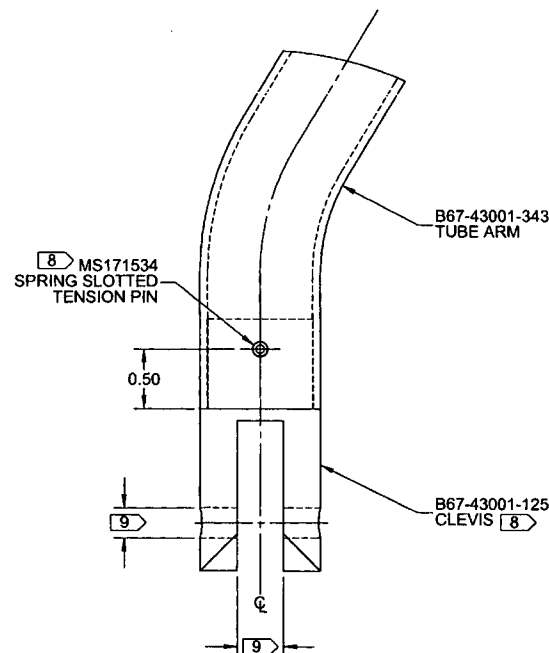
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ITEM	QTY -37	P/N	DESCRIPTION
1	X	B67-43001-37	TUBE ARM ASSEMBLY
3	1	B67-43001-343	TUBE ARM
4	1	B67-43001-125	CLEVIS
5	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)

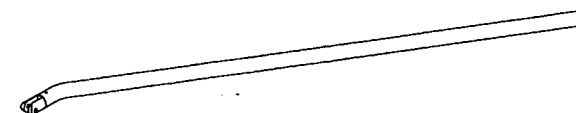


B67-43001-37 TUBE ARM ASSEMBLY



DETAIL A B7-1
SCALE 4 X

#53230



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.81 lbs
- 8) PRIOR TO POWDER COAT, ALIGN B67-43001-125 ON B67-43001-343 AS SHOWN AND DRILL A $\varnothing 0.129$ HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-125 TO B67-43001-343 USING MS171534 SPRING SLOTTED TENSION PIN
- 9) MASK PRIOR TO POWDER COAT

RELEASED
2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN			
CHECKED	BS		
MFG. APPR.	AD		
APPROVED	N/A		
DE APPR.			
DATE	09.06.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-37** REV. C
SHEET 1 OF 1
TITLE **TUBE ARM ASSEMBLY** SCALE NTS

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